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IS 1245 (1990): Handloom cotton pyjama cloth, grey [TXD 8: Handloom and Khadi]



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भारतीय मानक  
हथकरघा निर्मित पाजामे का सूती कपड़ा — विशिष्ट  
( पहला पुनरीक्षण )

*Indian Standard*

HANDLOOM COTTON PYJAMA CLOTH,  
GREY — SPECIFICATION

( *First Revision* )

UDC 677.21.074.172

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BUREAU OF INDIAN STANDARDS  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

## FOREWORD

This Indian Standard ( First Revision ) was adopted by the Bureau of Indian Standards on 26 June 1990, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1958. This standard has been revised in order to overcome certain difficulties encountered by the handloom industry in implementation of this standard.

Following are the important changes carried out while revising this standard:

- a) Use of cotton yarn conforming to IS 171 : 1985 has been specified.
- b) Constructional particulars have been modified taking into consideration present production patterns prevailing in the handloom industry.
- c) Only negative tolerances have been specified on ends/dm, picks/dm and mass g/m<sup>2</sup> to ensure minimum desirable construction. There being no tolerance on positive side on these requirements, it would provide flexibility to industry to adjust construction of the fabrics depending upon market demands.
- d) Breaking load requirement has been specified as optional requirement. This requirement has to be enforced in case it is not possible to establish that cotton yarn conforming to IS 171 : 1985 'Cotton and cotton regenerated cellulosic fibre blended yarn ( *third revision* )' has been used.
- e) Tolerance on length and width have been adopted from the instruction issued by the Central Government under *Trade and Merchandise Marks Act, 1958 ( 43 of 1958 )* as given in Notification No. S. O. 2937, dated 20 September 1962.
- f) For determining the conformity of the cloth to the requirements laid down in this standard, a provision has been incorporated to allow testing of specimens in prevailing atmospheric condition. However, in all cases of disputes specimens shall be tested after conditioning in the standard atmospheric conditions.
- g) Provision has been incorporated for agreement between the buyer and seller with respect to permissible number of defects in cotton pyjama cloth.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values ( *revised* )'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

**AMENDMENT NO. 1 JUNE 2003  
TO  
IS 1245 : 1990 HANDLOOM COTTON PYJAMA CLOTH,  
GREY — SPECIFICATION**

***(First Revision)***

*(Page 1, Table 1)* — Insert the following Note under the table:

'NOTE — Equal count of folded yarn may also be used.'

(TX 08)

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Reprography Unit, BIS, New Delhi, India

# Indian Standard

## HANDLOOM COTTON PYJAMA CLOTH, GREY — SPECIFICATION

( First Revision )

### 1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements for four varieties of handloom cotton pyjama cloth, grey.

1.2 This standard does not specify the general appearance, feel, finish, etc.

### 2 REFERENCES

2.1 The Indian Standards listed at Annex A are necessary adjuncts to this standard.

### 3 ATMOSPHERIC CONDITIONS FOR TESTING

3.1 Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of handloom cotton pyjama cloth to this standard. However, in all cases of disputes, specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

### 4 YARN

The cotton yarn used shall conform to the requirements specified in IS 171 : 1985.

### 5 REQUIREMENTS

5.1 The pyjama cloth shall conform to the requirements specified in Table 1.

5.2 The pyjama cloth shall also conform to the requirements specified in Table 2.

**Table 2 Other Requirements for Handloom Cotton Pyjama Cloth, Grey**  
( Clause 5.2 )

Characteristic	Requirement	Method of Test
(1)	(2)	(2)
1) Dimensional change, percent, <i>Max</i>	6	IS 2977 : 1989
2) Scouring loss percent, <i>Max</i>	10	IS 1383 : 1977
3) pH value of the aqueous extract	6.0 to 8.5	IS 1390 : 1983
4) Colour fastness:		
a) Light	4 or better	IS 686 : 1985 or IS 2454 : 1985
b) Washing : Test 4:		IS 765 : 1977
i) Change in colour	4 or better	
ii) Staining on fabric	4 or better	
c) Perspiration:		IS 971 : 1983
i) Change in colour	4 or better	
ii) Staining on fabric	4 or better	
d) Bleaching:		IS 762 : 1988
i) Change in colour	4 or better	
ii) Staining on fabric	4 or better	

5.3 The pyjama cloth shall be woven in plain weave.

**Table 1 Constructional Particulars and Breaking Load Requirements for Handloom Cotton Pyjama Cloth, Grey**  
( Clause 5.1 )

Variety No.	Count of Yarn ( for guidance only ) Cotton Count ( Universal Count )		Ends/dm	Picks/dm	Mass g/m <sup>2</sup>	Breaking Load in Newton	
						Warp	Weft
	Warp	Weft					
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
1	30 tex ( 20 <sup>s</sup> )	30 tex ( 20 <sup>s</sup> )	200	190	130	220	200
2	16 tex ( 36 <sup>s</sup> )	20 tex ( 30 <sup>s</sup> )	220	250	100	140	180
3	16 tex ( 36 <sup>s</sup> )	15 tex ( 40 <sup>s</sup> )	250	300	100	160	220
4	15 tex ( 40 <sup>s</sup> )	15 tex ( 40 <sup>s</sup> )	270	250	85	200	180
Tolerance, Percent	—	—	—5	—5	—5	—5 on Average value and —15 on Individual reading	
Method of Test	—	—	IS 1963 : 1981	IS 1964 : 1970 or Annex D	IS 1969 : 1985		

5.1.1 However, breaking load requirement shall be an optional requirement. It shall be enforced only when conformance of cotton yarn to the requirements specified in IS 171 : 1985 is not known.

### 5.4 Dimensions

Length and width of the pyjama cloth when determined in accordance with IS 1954 : 1969 shall be as agreed to between the buyer and the

seller or as declared by the seller subject to the tolerances specified in the Government of India, Ministry of Commerce and Industry Notification No. S. O. 2937 dated 20 September 1962 issued under *Trade and Merchandise Marks Act, 1958* ( 43 of 1958 ) ( see Annex B ).

**5.5** In order to illustrate or specify the indeterminable characteristics, such as general appearance lustre, feel and shade, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

**5.5.1** The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

## 6 INSPECTION

**6.1** The pyjama cloth when visually inspected should be free from the major flaws listed at Annex C.

**6.1.1** The number of permissible major flaws per unit length shall be as agreed to between the buyer and the seller.

**6.2** For details of the flaws mentioned in **6.1**, a reference may be made to IS 4125 : 1987.

## 7 SAMPLING

### 7.1 Lot

The quantity of the pyjama cloth of the same variety delivered to one buyer against one despatch note shall constitute a lot.

**7.2** The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

**7.3** Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 3.

**7.3.1** For selection of samples at random from the lot, procedure given in IS 4905 : 1968 may be followed.

**Table 3 Sample Size and Permissible Number of Non-Conforming Pieces**  
( Clause 7.3 )

Lot Size	Sample Size	Permissible Number of Non-Conforming Pieces	Sub-Sample Size
(1)	(2)	(3)	(4)
Up to 25	3	0	2
26 to 50	5	0	2
51 to 150	8	0	3
151 to 300	13	1	3
301 to 500	20	1	5
501 to 1 000	32	2	5
1 001 and above	50	3	8

## 7.4 Number of Samples and Criteria for Conformity

It shall be as follows:

Characteristics	Number of Samples	Criteria for Conformity
Ends, picks, mass, length, width and visual inspection	According to col 2 of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col 3
Dimensional change, colour fastness, scouring loss, pH value and breaking load	According to col 4 of Table 3	All the test pieces shall meet the requirement

## 8 MARKING

**8.1** The pyjama cloth shall be suitably marked with the following information:

- Name of the material and variety number;
- Length ( m ) and width ( cm ); and
- Indication of the source of manufacture.

**8.1.1** The pyjama cloth may also be marked with the Standard Mark.

## 9 PACKING

**9.1** Unless otherwise agreed upon by the buyer and seller the pyjama cloth shall be preferably packed in bales or cases in conformity with the procedure laid down in IS 1347 : 1972 or IS 293 : 1980.

## ANNEX A

( Clause 2.1 )

### LIST OF REFERRED INDIAN STANDARDS

IS No.	Title	IS No.	Title
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth ( <i>third revision</i> )	762 : 1988	Method for determination of colour fastness of textile materials to hypochloride bleaching ( <i>first revision</i> )
686 : 1985	Methods for determination of colour fastness of textile materials to daylight ( <i>first revision</i> )	765 : 1979	Method for determination of colour fastness of textile materials to washing : Test 4 ( <i>second revision</i> )



<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
971 : 1983	Method for determination of colour fastness of textile materials to perspiration ( <i>first revision</i> )	1964 : 1970	Methods for determination of weight per square metre and weight per linear metre of fabrics ( <i>first revision</i> )
1347 : 1972	Inland packaging of cotton cloth and yarn ( <i>first revision</i> )	1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics ( <i>second revision</i> )
1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials ( <i>first revision</i> )	2454 : 1985	Methods for determination of colour fastness of textile materials to artificial light (xenon lamp) ( <i>first revision</i> )
1390 : 1983	Methods for determination of pH value of aqueous extracts of textile materials ( <i>first revision</i> )	2977 : 1964	Method for determination of dimensional changes of woven fabrics (other than wool) on soaking in water ( <i>first revision</i> )
1954 : 1969	Methods for determination of length and width of fabrics ( <i>first revision</i> )	4125 : 1987	Glossary of terms pertaining to defects in fabrics ( <i>first revision</i> )
1963 : 1981	Methods for determination of threads per unit length in woven fabrics ( <i>second revision</i> )		

## ANNEX B

( Clause 5.4 )

### EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE AND INDUSTRY ( TRADE AND MERCHANDISE MARKS ) NOTIFICATION NO. S. O. 2937, DATED 20 SEPTEMBER 1962

**1** A trade description of length stamped on grey, bleached, mercerised or coloured cotton piece goods:

- in pieces stamped as of length 9 metres and below the stamped length shall not exceed the actual length by more than 1 percent of the piece length or 7.5 cm whichever is less, and;
- in pieces stamped as of length above 9 metres the stamped length shall not exceed the actual length by more than 0.6 percent of the piece length or 7.5 cm whichever is higher.

Provided that the average length of the pieces in question shall not be less than the stamped length.

**2** A trade description of width stamped on grey, bleached, mercerised or coloured cotton piece

goods:

- in pieces stamped as of width 102 cm or below, the stamped width shall not exceed the actual width at any point by more than 1.3 cm.
- in pieces stamped as of width over 102 cm up to 152 cm the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece;
- in pieces stamped as of width 152 cm and above the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece or 2.5 cm whichever is less.

Provided that average width of the piece in question shall not be less than the stamped width.

## ANNEX C

( Clause 6.1 )

### LIST OF MAJOR FLAWS

One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm,

or prominently noticeable double and running throughout the piece.

Undressed snarls noticeable over a length

exceeding 5 percent of the length of the piece.	Noticeable warp or weft float in the body of the fabric.
Smash definitely rupturing the texture of the fabric.	Noticeable oil or other stains in the fabric.
Hole, cut or tear.	Oily weft in the fabric.
Reed marks prominently noticeable over a length exceeding 5 percent of the piece.	Prominently noticeable slub.
Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece.	Conspicuous broken pattern.
Skewing of more than three percent on weft.	Gout due to foreign matter, usually lint or waste woven into the fabric.
Weft crack or two or more missing picks across the width of the fabric.	Prominent selvedge defect.
Warp or weft bar due to the difference in raw material, count, twist, lustre, colour, shade or spacing of adjacent groups of yarns ( starting marks ).	Significant shading or listing in fabrics having a gradual change in tone or depth of shade of fabric ( excluding selvedge or border running parallel to the selvedge ).
More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm.	Coloured flecks.
	Blurred or dark patch.
	Patchy, streaky or uneven dyeing.
	Dye bar.
	Fuzzy appearance.

ANNEX D

( Table 1 )

METHOD FOR DETERMINATION OF MASS OF FABRIC

- D-1** Cut four specimens of 100 mm × 100 mm from a sample. Condition all the specimens in the dessicator charged with saturated solution of sodium nitrate at  $27 \pm 2^{\circ}\text{C}$  for a period of 24 hours. Remove all the specimens from the
- dessicator and immediately determine their collective mass in weighing balance to the nearest milligram.

**D-2** Calculate mass of fabric in  $\text{g/m}^2$ .

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## **BUREAU OF INDIAN STANDARDS**

### **Headquarters :**

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002  
Telephones : 331 01 31, 331 13 75

Telegrams : Manaksanstha  
( Common to all Offices )

### **Regional Offices :**

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg  
NEW DELHI 110002

Telephone

{ 331 01 31  
331 13 75

Eastern : 1/14 C.I.T. Scheme VII M, V.I.P. Road, Maniktola  
CALCUTTA 700054

37 86 62

Northern : SCO 445-446, Sector 35-C, CHANDIGARH 160036

2 18 43

Southern : C.I.T. Campus, IV Cross Road, MADRAS 600113

41 29 16

Western : Manakalaya, E9 MIDC, Marol, Andheri ( East )  
BOMBAY 400093

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